

Sometimes removable bushings are threaded on the outside and made to fit a tapped hole in the jig, as shown in Fig. 10. The lower part of the bushing is usually turned straight, and ground, in order to center the bushing perfectly in the hole in the jig. The head of the bushing is either knurled or milled hexagon for a wrench. When these bushings are used, they are, as a rule, not used for the single purpose of guiding the cutting tool, but they combine with this the purposes of locating and clamping the work. For such

Table IV. Bushings for Holes
Reamed with Rose Chucking Reamefs

ffi
L..

^T

TT
lif
e

.. — F —

I

—
1
!

Af

⁷⁶ i	e	1			1	2'	2J/	
M	1	9	2	I	M	!	2	3
e	9	4	9	M	e	9	2	H
I	6		6	I	a	1	M	a
					i	e	a	
I	IM		294	I	9	2	21	
H	e	2		1	1	2	I ¹	
e	i	M		e	9	H	e	35
iM				H	6		3	6
a	H	e		e	9		3	
I	M				6	I'	Me	21
				I	M	2M	2	3
						e	2	%
							Ha	3
								Ha
								3

[illegible]